

018-022 DUE

Dart Aerospace Ltd.

Date
UserThursday, 7/19/2007 2:25:01 PM
Kim Johnston

Process Sheet

SPL, H 31

Customer : CU-DAR001 Dart Helicopters Services
 Job Number : 33650A - 2
 Estimate Number : 11703
 P.O. Number : N/A
 This Issue : 7/19/2007 S.O. No. : N/A
 Prsht Rev. : NC
 First Issue : N/A Type : LARGE FAB ASSY
 Previous Run : 32392A
 Written By : 07.07.19
 Checked & Approved By : 07.07.19
 Comment : Est Rev:E As Per Ecn 766 06-01-06 JLM

Drawing Name : 206L/407 STEP ASSY, RH

Part Number : D2724042
 Drawing Number : D2724 REV C
 Project Number : N/A
 Drawing Revision : C
 Material : N/A
 Due Date : 8/3/2007

Qty: 3 Um: Each

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description:

1.0

D2622120C

Extrusion



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)
 Qty Part # Description Batch:
 1 D2622-120C Extrusion 832858

Check Material for any Dents or Defects

a.m 07.07.23 3

2.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Cut D2724-2 using D2622 extrusion as per Dwg D2724
 Deburr and bevel ends for welding

a.m 07.07.23 3

3.0

D2734

206 Step Endplate



Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)
 206 Step Endplate

Pick:

Qty Part Number Description Batch
 2 D2734 End Cap 330883

07.07.24 3

4.0

D34581

PLATE



Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)
 Pick:

Qty Part Number Description Batch
 2 D3458-1 Plate 332480

07.07.24 3

Thursday, 7/19/2007 2:25:01 PM

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L /407 STEP ASSY, RH

Job Number: 33650A

Part Number: D2724042

Job Number:



Seq. #:

Machine Or Operation:

Description:

5.0

D34583

PLATE



Comment: Qty.: 2.0000 Each(s)/Unit Total: 6.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 D3458-3

Plate

3.32481

6.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld end cap and lugs as per Dwg D2724 using Jig DT followed by Jig

DT (One End Only)

A/R AL ROD Batch: M104721

M103794

Grind end cap welds flush

07.07.24 3

07.07.24 3

7.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

9.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

11.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Inspect for foreign object per QSI 024

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L /407 STEP ASSY, RH

Job Number: 33650A

Part Number: D2724042

Job Number



Seq. #:

Machine Or Operation:

Description:

Weld Remaining end cap as per Dwg D2724 using Jig DT followed by Jig
DT
A/R AL ROD Batch: m103794

Pl. 07-07-25 3
Pl. 07-07-25 3

Grind end plate flush.

a.n

07-07-26

3

12.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 07-07-26 (3)

13.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

En 07-07-26 (3) EH

14.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Touch up Alodine

HL

07-07-27

(3)

15.0

PG

PURCHASING



Comment: ISSUE P.O. 4173
ATELIER DEBOSSelage
SPRAY PAINT DELFLEET BLUE
CLEAR DELFLEET

U

07-07-27

3

16.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

RECEIVE AND INSPECT FOR TRANSIT DAMAGE

07/12/12 (3)

17.0

QC14

INSPECT SPRAY PAINT



Comment: INSPECT SPRAY PAINT

En 07/08/09 (3) EH

18.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: Wing Walk as per Dwg D2724 and QSI 00 5 4.4

m104942

FD 07/08/12 (3)

Thursday, 7/19/2007 2:25:01 PM

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L /407 STEP ASSY, RH

Job Number: 33650A

Part Number: D2724042

Job Number:



Seq. #:

Machine Or Operation:

Description:

19.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

En 07/08/14 (7.384)

20.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

PPP B 33650

07/19/07

2

21.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/09/10 (2)

Job Completion:



u 070907

DART

RELEASED

05.11.14

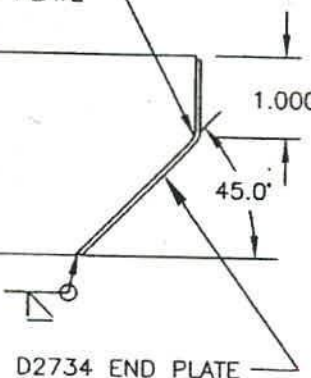
NOTE: ALL WELDS SHALL
BE 100% VISUALLY
INSPECTED BY A QUALIFIED
INSPECTOR PER DART
QSI 004

APPLY BLACK
ANTI-SKID ON
TOP SURFACE
TO BOTTOM
OF TOP RADIUS

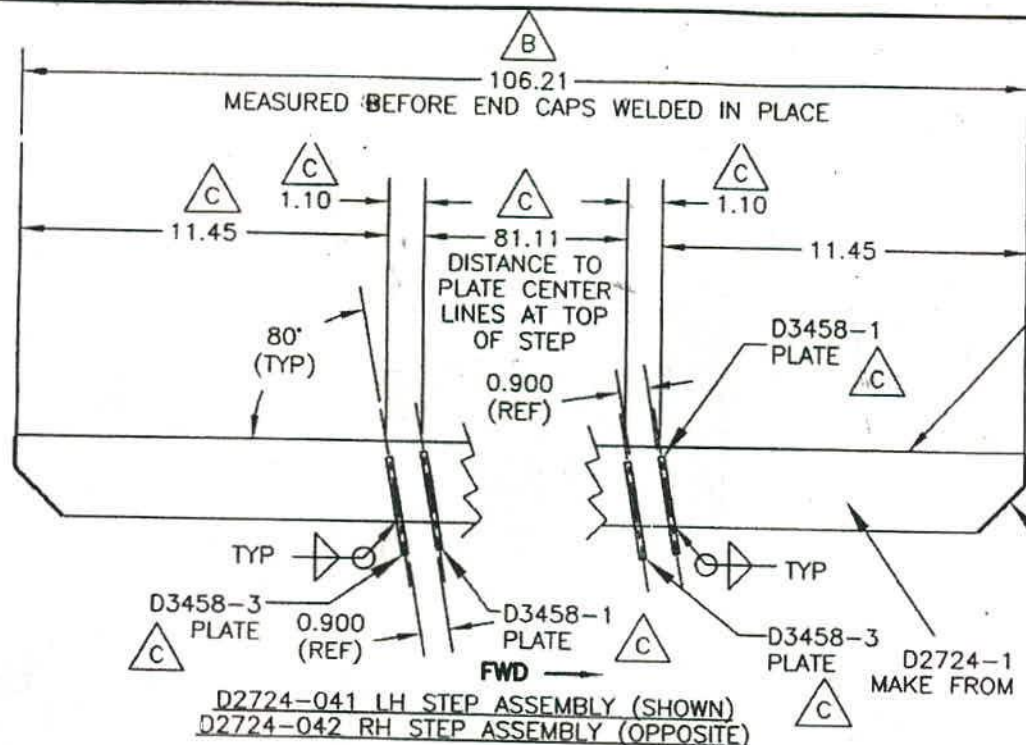
REFER TO STEP
END DETAIL

D2724-1
MAKE FROM EXTRUSION D2622-107

ROUND CORNER OF EXTRUSION TO
MATCH BEND RADIUS OF END PLATE



TYPICAL STEP END DETAIL
NOT TO SCALE



D2724-041 LH STEP ASSEMBLY (SHOWN)
D2724-042 RH STEP ASSEMBLY (OPPOSITE)

D2721-041/-042 STEP ASSEMBLY PARTS LIST

QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X		D2724-041	LH STEP ASSEMBLY
	X	D2724-042	RH STEP ASSEMBLY
1	1	D2622-107	EXTRUSION
2	2	D2734	END PLATE
2	2	D3458-1	PLATE
2	2	D3458-3	PLATE

D2724-041/-042 STEP ASSEMBLY

- 1) MAKE FROM EXTRUSION D2622
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
APPLY BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
336504

DESIGN	KE	DRAWN BY	PH	DART AEROSPACE USA, INC.
CHECKED		APPROVED		PORT HADLOCK, WA
DATE	05.09.19			DRAWING NO. D2724
				REVISIONS
				05.09.19
				98.10.19
				97.12.04
				05.09.19
				RE-DESIGN, ADD D3458-1/-3
				UPDATED WELD DETAIL REVISED TOLERANCES
				NEW ISSUE
				206L/407 STEP ASSEMBLY
				SHEET 1 OF 1
				SCALE NTS